



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

C250-200
Job Sheet 174913



Part No: C250-200

Job Qty: 2 ea

Part Name: Side Plate Housing



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/23/18

Job Tracking No:

Due Date: 3/30/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG C250-200 REV:4 IPP REV A 18.02.27 NEW ISSUE RQ VERIFIED BY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	3 Ea		3/29/18	0.00	0.00	Start Up Machining		J.C.L.
110	Mori Seiki	3 pcs		3/29/18	0.00	3.00	MORI NV5000-1		J.C.L.
120	QC	3 pcs		3/29/18	0.00	0.00	QC2		J.C.L. 18-04-22
130	QC	3 pcs		3/29/18	0.00	0.00	QC8		D.A. 18-04-24
150	Outsource	3 pcs		3/29/18	0.00	0.00	Outsource4		CT 18-4-24
160	Packaging	3 pcs		3/29/18	0.00	0.00	Packaging2		AT 18-04-27
170	QC	3 pcs		3/29/18	0.00	0.00	QC6		AD 18-04-28
175	Small Fab	3 pcs		3/30/18	0.00	0.75	Small Fab-9		M.L.
180	QC	3 pcs		3/30/18	0.00	0.00	QC5		D.A. 21
185	Packaging	3 pcs		3/30/18	0.00	0.00	Packaging3		21
190	QC21-SA	3 Ea		3/30/18	0.00	0.00	QC21		APR 27 2018

Part Op 110 - 1-Machine as per folio FB FOLIO REV: _____ DWG REV: _____ 2-Deburr
Descriptions: 150 - Issue P/O to ATG ALTECHPOSITIVE ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required 120 - Engrave S/N using Mark/ronic engraver.
175 - Laser Etch, white as per dwg. See note 1 for location.

P0039685

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S2.250X13.500	6061-T6 Sheet 2.250" Thick x 13.500" Wide	4.1400 ft (1.38 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6S2.250X13.500	4	6	0



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
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Email: sales@dartaero.com
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Part Specifications

Specifications could not be found.

Container No: S063697



Part: C250-200

Job No: 174913

Serial No/Batch: S063697

Revision: 4

Inspector:

Plex 3/23/18 9:15 AM Dart.lajeunesse.marie

DART AEROSPACE LTD		Work Order:	17-1513
Description: Side Plate Housing		Part Number:	C250-200
Inspection Dwg: C250-200	Rev: 3	Page 1 of 1	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
16.36	± 0.00	16.357	✓		Caliper	A 1000
17.15	± 0.010	17.147	✓			
6.47	± 0.010	6.470	✓		17.6.	31006
3.50	± 0.010	3.500	✓			
3.750	± 0.005	3.750	✓		Caliper	JCL-08
1.060	± 0.004	1.060	✓		Caliper	JCL-08
1.188	± 0.004	1.189	✓			
Ø 1.28	± 0.012	1.279	✓			
4.64	± 0.010	4.640	✓			
4.98	± 0.010	4.980	✓			
Ø 1.03	± 0.012	1.029	✓			
9.19	± 0.010	9.190	✓			
4.17	± 0.010	4.170	✓			
7.27	± 0.010	7.27	✓			
9.01	± 0.010	9.010	✓			
Ø 0.156	± 0.005	0.157	✓			
Ø 0.316	± 0.006	0.316	✓			
I 1.125	± 0.005	1.125	✓			
10-32 UNF	2B	O.K.	✓		60-11060	HT-277
Ø 0.250	± 0.005	0.250	✓		Caliper	JCL-08
Ø 0.625	± 0.008	0.625	✓			
I 1.460	± 0.005	1.460	✓			
Ø 0.9363	± 0.0005	0.9365	✓		Pin Gauge	
Ø 1.290	± 0.012	1.290	✓		Caliper	JCL-08
I 1.145	± 0.005	1.148	✓			
Ø 0.6246	± 0.0002	0.6245	✓		Pin Gauge	
Ø 0.750	± 0.008	0.755	✓		Caliper	JCL-08
Ø 0.500	± 0.006	0.501	✓			
Ø 1.000	± 0.012	1.001	✓			

Measured by: JCL	Checked by: D.F.	QC Inspector:
Date: 18-04-22	Date: 18-04-24	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

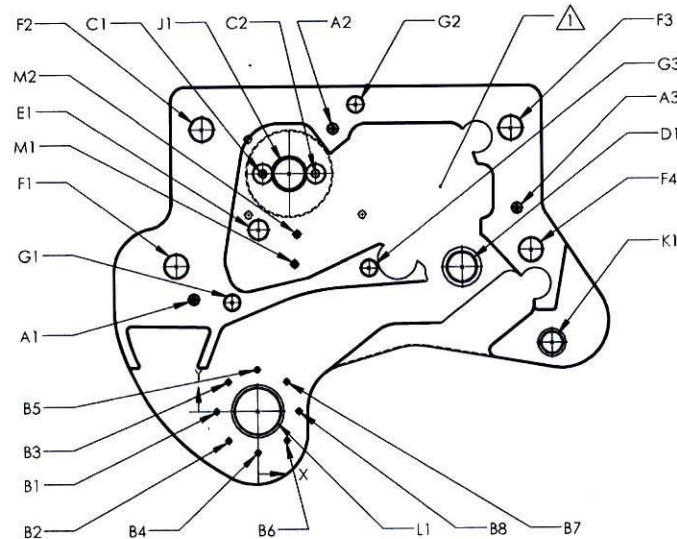
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____					

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TAG	X LOC	Y LOC	SIZE
A1	-2.088	3.700	Ø .156 THRU ALL
A2	2.560	9.310	Ø .316 ± 1.125
A3	8.600	6.656	Ø .316 ± 1.125
B1	-1.368	-.000	10-32 UNF - 28 THRU ALL
B2	-.967	-.967	
B3	-.967	.967	
B4	.000	-1.368	
B5	-.000	1.368	
B6	.967	-.967	
B7	.967	.967	
B8	1.368	.000	
C1	.236	7.831	Ø .250 THRU ALL
C2	1.986	7.831	Ø .250 THRU ALL
D1	6.763	4.721	Ø .9363 THRU ALL
E1	.081	5.980	Ø .6248 THRU ALL
F1	-2.659	4.796	Ø .750 THRU ALL
F2	-1.793	9.299	2X .03 X 45°
F3	8.407	9.299	2X .03 X 45°
F4	9.055	5.274	2X .03 X 45°
G1	-.817	3.592	Ø .500 THRU ALL
G2	3.307	10.093	2X .03 X 45°
G3	3.712	4.709	2X .03 X 45°
J1	1.111	7.831	Ø 1.001 THRU ALL
K1	9.717	2.207	Ø .689 ± .002 THRU ALL
L1	.000	.000	Ø 1.501 ± .001 THRU ALL
M1	1.269	4.843	Ø .188 ± 1.685
M2	1.356	5.828	Ø .188 ± 1.685

REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		AS DRAWN BY APICAL	6/11/2013	CFL	
2		CHD E1 HOLE TOLERANCE WAS Ø.627 ± .002 ± .001 B Ø.6248-6244.	6/28/2013	CFL	JAG
3		CHD E1 HOLE CHAMFER WAS .03 X 15° E .03 X 45°.	8/20/2013	CFL	JAG
4	14-0128	CHD TITLE BLOCK WAS RED BARN B DART. ADDED MACHINE ENGRAVE NOTE. CHD DIMS WAS (13.151) E 13.15, WAS (16.361) E 16.36, WAS (3.50) B 3.50 DELETED DIM Ø.915, ADDED DWF NOTE.	8/14/2014	DPD	RW



NOTE:
MACHINE ENGRAVE BATCH NUMBER.

DART AEROSPACE	
TITLE SIDE PLATE HOUSING	
DWG NO. C250-200	REV 3
MAT'L 6061	DRAWN BY: APICAL
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES XXX ± .005 XX ± .01 X ± .1	APPROVED D. Well BLACK ANODIZE SPEC MIL-A-8625F, TYPE II, CLASS II USED ON MODEL
1. BREAK ALL SHARP EDGES .015 X 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:4	DATE 6/13/2011
SHEET 1 OF 2	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS
			C250-200	1	SIDE PLATE HOUSING	6061	2-18 X 13-1/4 X 16-1/2

REVISIONS					
REV	ECP	DESCRIPTION	DATE	INITIAL	APPROVED
1		CHD EI HOLE TOLERANCE WAS Ø .627 + .000 - .001 IS Ø .6249-.6244.	6/28/2013	CF5	JAG
2		CHD EI HOLE CHAMFER WAS .03 X 15° R .03 X 45°.	8/20/2013	CF5	JAG
3	14-0128	CHD DIMS WAS {13.15} IS 12.15, WAS {16.36} IS 16.36, WAS {3.50} IS 3.50. DELETED DIM Ø.915. ADDED DXF NOTE.	8/14/2014	DPD	RW



	
SIDE PLATE HOUSING	
TITLE	
DWG NO.	C250-200
REV	3
MATL. 6061	DRAWN BY: APICAL
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED: <i>D. Wed</i>
XXX ± .005 FRACTIONS 1/16	FINISH
.XX ± .01 ANGLES .5°	BLACK ANODIZE
.X ± .1	SPEC MIL-A-8625F, TYPE II, CLASS II
1. BREAK ALL SHARP EDGES .015 X 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:4	DATE 6/13/2011
	SHEET 2 OF 2



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO039685**

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO039685
PO Date: 4/24/18
Due Date: 4/27/18
Purchase Order Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Via: Ground
Pynt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	174914	C250-100	Side Plate Cover -Issue P/O to ATG: _____ -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed	4/27/18	3 pcs	0 pcs	3 pcs	\$58.50/pcs	\$175.50
2	174913	C250-200	Side Plate Housing -Issue P/O to ATG: _____ -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed	4/27/18	4 pcs	0 pcs	4 pcs	\$58.50/pcs	\$234.00
Grand Total:										\$409.50

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retension of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.



Certificat de Conformité / Certificate of Compliance

(008715-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

008715- 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
27-Apr-2018		Aman		039685				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	C250-100 Rev.	C250-100 01 -ANO-BLACK [ANODIZE BLACK] TYPE 2 CLASS 2 WATER SEALANT	ANODIZE CH	3	3	0	0	0
2	C250-200 Rev.	C250-200 01 -ANO-BLACK [ANODIZE BLACK] TYPE 2 CLASS 2 WATER SEALANT	ANODIZE CH	4	3	0	0	0

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.